

CLAIMS:

1. Method for the production of a flange on a circular metal blank by means of at least one or more pressure roller(s), characterized in that
  - a) by means of at least one pressure roller (3), a particularly conically shaped structure (4), which tapers toward the median perpendicular (S) of the circular metal blank (1), is formed on the circular metal blank, and
  - b) from the conical structure (4), a flange (7) is formed on the circular metal blank (1) by means of a subsequent treatment.
2. Method for the production of a flange on a circular metal blank by means of at least one or more pressure roller(s), characterized in that
  - a) by means of the at least one pressure roller (3), the axial thickness of the circular metal blank is reduced at least in sections along its radial dimension and the material is shaped into a hub-type structure and/or a structure which is conical particularly with respect to the median perpendicular,
  - b) from the hub-type and/or conical structure (4), a flange (7) is formed on the circular metal blank (1) by means of a subsequent treatment.
3. Method according to one of the preceding claims, characterized in that the axial dimension or height of the flange (7) is smaller than its radial dimension.
4. Method according to one of the preceding claims, characterized in that the radial dimension of the flange (7) is more than twice, particularly more than three times as large as its axial dimension.
5. Method according to one of the preceding claims, characterized in that the axial extension of the flange (7) is only slightly larger than the thickness of the starting circular blank.

6. Method according to one of the preceding claims, characterized in that the pressure roller is sunk in Step "a" first into the metal roller (circular metal blank? translator) and is then radially moved from the outside toward the inside.

7. Method according to one of the preceding claims, characterized in that the adjustment angle ( $\alpha$ ) of the pressure roller (3) relative to the axial surface of the circular metal blank (1) is greater than  $90^\circ$ .

8. Method according to Claim 7, characterized in that the adjustment angle ( $\alpha$ ) of the pressure roller (3) relative to the axial surface of the circular metal blank is greater than  $110^\circ$  and smaller than  $170^\circ$ .

9. Method according to Claim 8, characterized in that the adjustment angle ( $\alpha$ ) of the pressure roller (3) relative to the axial surface of the circular metal blank is greater  $115^\circ$  and smaller than  $150^\circ$ .

10. Method according to one of the preceding claims, characterized in that, during (the forming? something is missing in the German - translator) of the conical structure, simultaneously an axially and/or radially adjustable hold-down roller is also running particularly on the side situated opposite the pressure roller and presses down the circular metal blank at least in sections such that the latter does not lift off the tool (11) or arch forward in the area in which the pressure roller (3) is moving.

11. Method according to one of the preceding claims, characterized in that the subsequent treatment takes place by means of an additional pressure roller (5, 6).

12. Method according to Claim 10, characterized in that the additional pressure roller (5) sinks axially into the conical structure (4) during the subsequent treatment.

13. Method according to Claim 11, characterized in that the additional pressure roller (6) sinks radially into the conical structure (4) during the subsequent treatment.

14. Method according to one of the preceding claims, characterized in that the subsequent treatment takes place by means of a press.

15. Method according to one of the preceding claims, characterized in that the inside diameter of the circular metal blank (1) with the flange (7) after the Steps "a" and "b" is smaller than the inside diameter of the centric bore (2) of the circular metal blank (1) in the starting workpiece.

16. Method according to one of the preceding claims, characterized in that the circular metal blank (1) in Step "a" is penetrated by a conically tapering mandrel.

17. Method according to one of the preceding claims, characterized in that the circular metal blank (1) is held by an abutment chuck on its outer circumference.

18. Method according to one of the preceding claims, characterized in that, in addition, the circular metal blank (1) is held down on its side facing the pressure roller by means of a ring.

19. Method according to one of the preceding claims, characterized in that, in addition, the circular metal blank (1) is held down on its side facing the pressure roller at least in sections by means of a hold-down roller.

20. Method according to one of the preceding claims, characterized in that the flange is constructed on the side of the circular metal blank facing away from the pressure roller.

21. Method according to one of the preceding claims, characterized in that the flange is formed on the side of the circular metal blank facing the pressure roller.

22. Method according to one of the preceding claims, characterized in that the flange extends on both axial sides of the circular metal blank.

23. Method according to one of the preceding claims, characterized in that the flange is pressed into a tool having a contour, particularly a toothing, so that, on its side facing the tool, the flange is provided with a corresponding contour, particularly a toothing (10).

24. Method according to one of the preceding claims, characterized in that the tool (11) rotates during the treatment.

25. Method according to one of the preceding claims, characterized in that the pressure rollers and/or hold-down rollers are disposed in a rotatable manner.

26. Transmission part having a flange around a centric bore, characterized in that the flange is produced corresponding to a method according to one of the preceding claims and is connected in one piece with the remaining transmission part.

27. Transmission part according to Claim 22, characterized in that the transmission part is constructed as a starter rim which is produced from a circular blank of fewer than 7 mm, particularly fewer than 5 mm, preferably fewer 4 mm, the

starter rim, in sections, being thinner than the starting width of the circular blank, and the starting rim having a flange toward an inner passage hole, which flange is formed in one piece by means of the pressing method.